

Work Order ID 130854

March-26-15 1:24:45 PM

646.9710
B130854
REV: C

130854

Page 1

Item ID: 646.9710

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Body

Start Date: 3/26/15

Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 150327

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	C (ECN)

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 7.425"

0.00

0.00

3

0

DAS
40
9-89

15/03/27

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB130

DWG REV: C

FOLIO REV: AA

0.00

0.00

3

1

DAS
40
9-89

15/5-28
PTC

2- deburr and break all sharp edges

DQA:

Date:

15/05/26



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/05/19.

Work Order update only ☐

Work Order: <u>130854</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>616.710</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4971</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/03/27	110	1	ORIGIN IN SECOND OP WAS WRONG. OPER CRACK ERROR.		SCRAP DESTROY Full 15.03.31	DAS 40 9-89 15/03/27	Full 15.03.31	PD 1503-31
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator					15/05/12 Q22042				
Offset/Setup									
Process									
Supplier				R.C. operator					
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☒ Outside Dimensions ☒ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130854

130854

Page 2

March-26-15 1:24:45 PM

Item ID: 646.9710

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Body

Start Date: 3/26/15

Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

3 1 SL153-28

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B- 15/03/31

3 0 DAS
08
9-89

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG :

27887

1- Black Anodize as per Dwg 646.9700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

3 62 APR 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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March-26-15 1:24:45 PM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:
Customer:

Cust Item ID:
Customer:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

150	Receive & Inspect for Damage & Mat'l Certs	0.00	
150			
Packaging	Memo	0.00	3x Sp 15-01-24

150

Packaging

Packaging

155	QC5- Inspect part completeness to step on W/O	0.00	
155			3
QC	Memo	0.00	
Quality Control			MAY 01 2015

155

QC

Quality Control

180	Identify as per dwg & Stock Location: <u> </u>	0.00	
180			
Packaging	Memo	0.00	
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***		

3 DAS
27
8-29
MAY 05 2015

180

180

Packaging

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:24:45 PM

Page 1

Work Order ID: 130854

130854

Parent Item: 646.9710

646.9710

Parent Item Name: Body

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B5.000X1.000		Purchased			No	100	f	38.0950	0.62	2			

M7075T6B5 000X1 000

**

7075-T6 BAR 5.000" X 1.000"

15-3-28

Location

Loc Qty

Loc Code

MAT005

38.095

M126981

9.72 X 3

M127481

28.375 X 1

X 1.9
-63

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Material									
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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

PREPARED BY D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

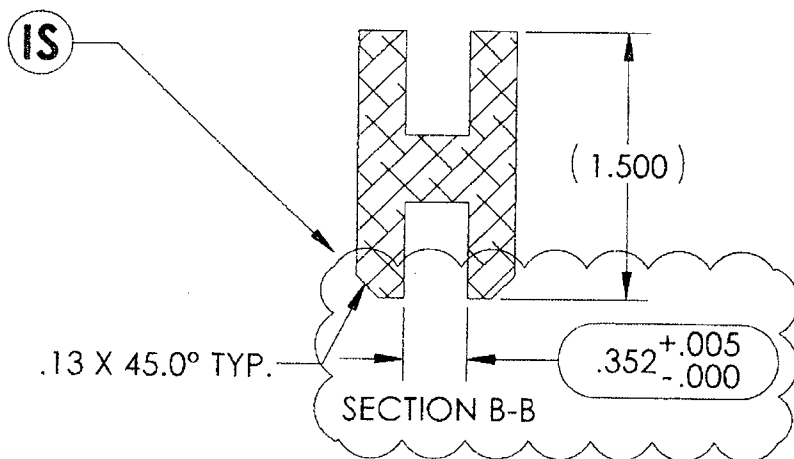
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

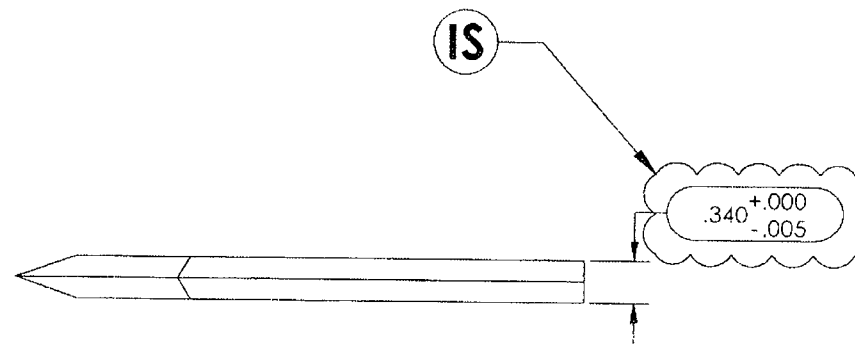
REASON: ADDED DIMENSION AND TOLERANCE

ECR: D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



SHAW-WORTH COPY
REPRODUCTION
NOT FOR CONSTRUCTION
FOR INFORMATION
ONLY
130854 MLS
15-03-27

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

NOTES:

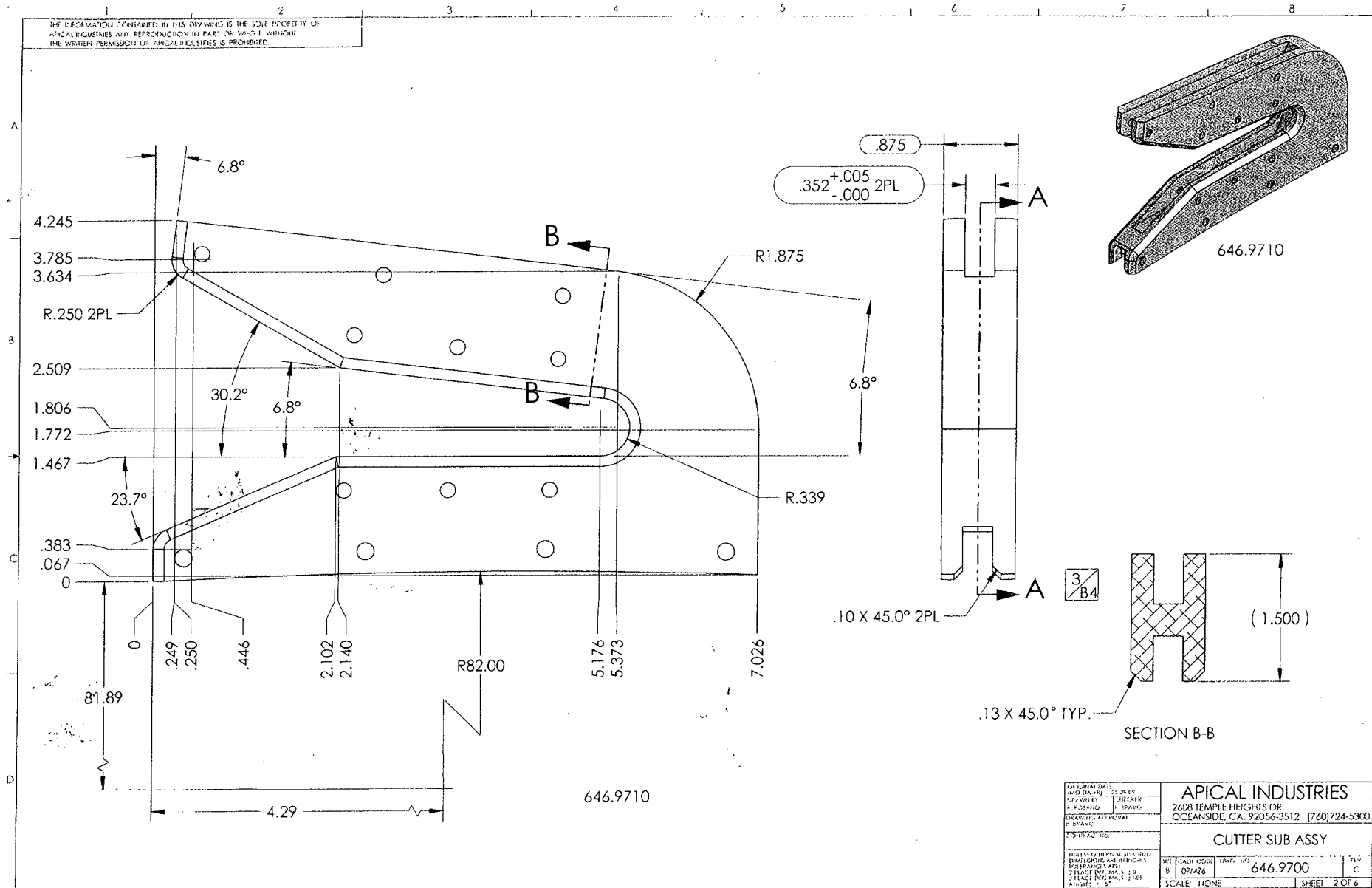
- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- ⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

UNINCORPORATED ECN(S)

04550

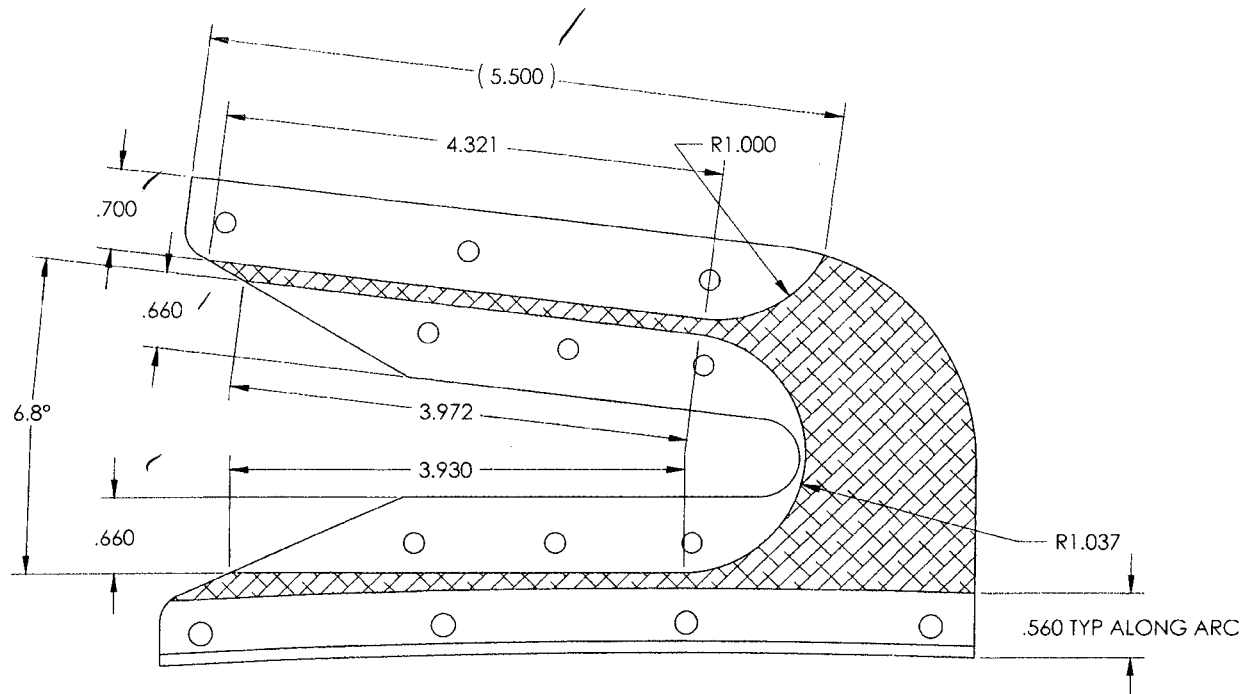
1		7	646.9712	BODY (U CHANNEL)		△	△
6	6	6	601.1541	LOCKNUT	MS21042L08		
A/R	A/R	5	601.2764	RTV. LOCUTE 598			
12	12	4	601.2764	WASHER	1MS1 47H-053H		
6	6	3	601.2165	SCREW	MS270309 20-18		
2	2	2	646.9711	BLADE			△
	1	1	646.9710	BODY			△
			646.9702	CUTTER SUB ASSY (U CHANNEL)			
			646.9701	CUTTER SUB ASSY			
QTY	QTY	FIND #	PART #	DESCRIPTION	MAT'L		SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
646.9600				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
ORIGINAL DATE 10/01/82 BY: JMS 2289 REVISIONS: 1. 01/01/83 J. D'AMICO 2. 03/24/83 J. D'AMICO REWORKED: 01/01/84 BY: JMS 3. 03/26/84 J. D'AMICO 3/25/84 J. D'AMICO				CUTTER SUB ASSY			
JULIUS ROSENBERG VINCIGUERRA INDUSTRIES 4000 W. 204TH ST. ST. LOUIS, MO 63114 TEL: (314) 861-5400 FAX: (314) 861-5400 C. ROSENBERG J. D'AMICO				CUTTER SUB ASSY			
REV	DATE	BY	DESCRIPTION	REV	DATE	BY	DESCRIPTION
0	DTM/66			0			
SCALE: NONE				1 SHEET 1 OF 6			

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



CALCULATED BY: DESIGNED BY: CHECKED BY: DRAWING APPROVAL: DATE:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
PART NAME: PART NUMBER:		CUTTER SUB ASSY 646.9700	
MATERIAL: QUANTITY: DATE:	SCALE: SHEET:	REV: C	SHEET 2 OF 6

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES AND REPRODUCTION IN ANY MANNER WITHOUT
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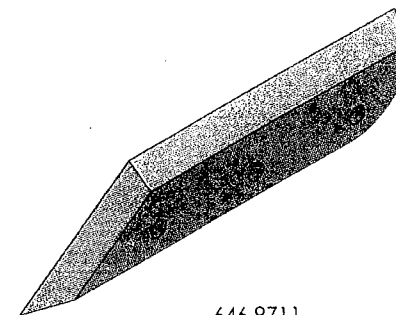
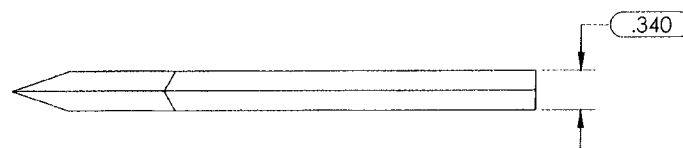


SECTION A-A 2/C6

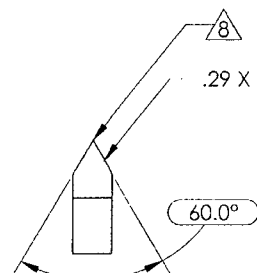
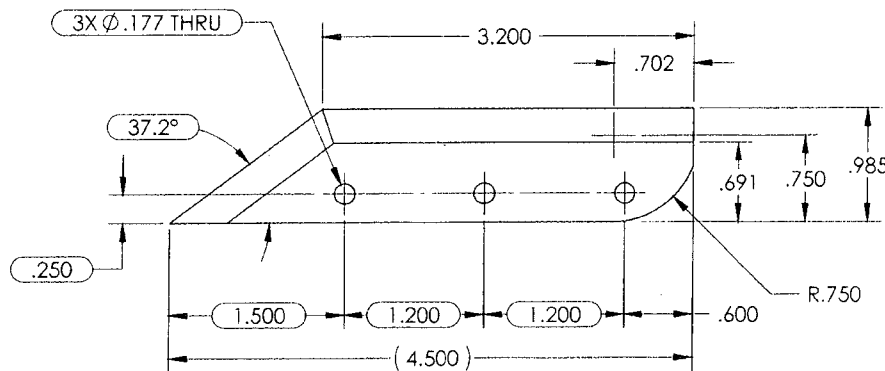
646.9710

CALCULATED DATE: 01/01/00 DRAWN BY: J. BRADY CHECKED BY: J. BRADY DESIGNED BY: J. BRADY DATE: 01/01/00		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
MATERIAL: 304 STAINLESS STEEL FINISH: POLISHED TOLERANCES: .005 UNLESS OTHERWISE SPECIFIED		CUTTER SUB ASSY	
REV	DATE	BY	CHK
B	07/02/00	646.9700	C
SCALE: NONE		SHEET 3 OF 6	

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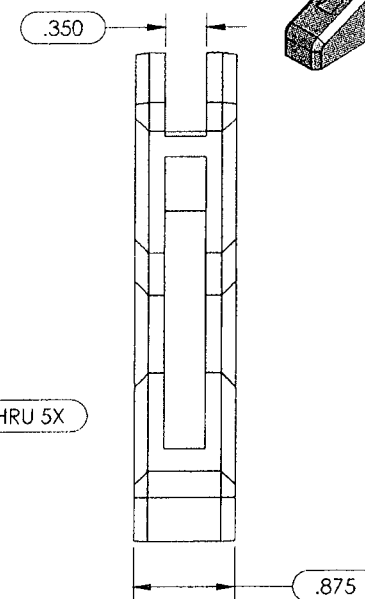
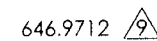


646.9711



646.9711

QUOTE DATE: 07-29-13 DRAWN BY: J. SPENCER CHECKED BY: J. SPENCER DESIGNED BY: J. SPENCER P. SCALE: 1"=1" P. SHEET: 1 OF 6		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
TITLE: CUTTER SUB ASSY PART NO: 646.9700 REV: 07/11/16		CUTTER SUB ASSY SCALE: NONE SHEET: 5 OF 6	

[illegible]

GANGING, DPM		05/29/09	
IMC DA 101			
DRAWING: R		PROJECT: R	
BY: JACOB		BY: JACOB	
ISSUED: APPROVAL			
R: JACOB/20 25/06			
CONTRACT NO.			
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCTANSIDE, CA. 92056-3512 (760)724-5300			
CUTTER SUB ASSY			
UNITS CONTAINED: 30 UNITS REQUIRED: 30 2 PLAIN (2) 4.00 3 PLAIN (3) 2.00 3 PLAIN (3) 1.00		QTY CASE CODE 6 04M66	UNIT PRICE 646.9700
SCALE NONE		REV C 3 OF 6	

DART AEROSPACE LTD		Work Order:	130854
Description: Body		Part Number:	646.9710
Inspection Dwg: 646.9700 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13 x 45°	+/-0.010 x 0.5°	13X45°	/		VRN	SL-6
1.500	+/-0.005	1.500	/		-	
0.352	+0.005/-0.000	0.353	/		g-pin	
0.10 x 45°	+/-0.010 x 0.5°	0.95X45°	/		VRN	SL-10
0.875	+/-0.005	0.879	/		-	
0.700	+/-0.005	0.698	/		-	
5.500	+/-0.005	5.500	/		-	
0.660	+/-0.005	0.658	/		H-G	
0.660	+/-0.005	0.659	/		H-G	
0.278	+/-0.002	0.278	/		H-G	
0.339	+/-0.002	0.339	/		-	
0.352	+/-0.002	0.352	/		-	
0.372	+/-0.002	0.372	/		-	
1.067	+/-0.002	1.067	/		-	
2.608	+/-0.002	2.607	/		-	
2.750	+/-0.002	2.750	/		-	
2.892	+/-0.002	2.891	/		-	
3.348	+/-0.002	3.348	/		-	
3.597	+/-0.002	3.597	/		-	
3.847	+/-0.002	3.846	/		-	
0.351	+/-0.002	0.351	/		VRN	
0.544	+/-0.002	0.543	/		H-G	
2.195	+/-0.002	2.195	/			
2.304	+/-0.002	2.304	/			
2.451	+/-0.002	2.451	/		VRN	
2.639	+/-0.002	2.638	/			
3.395	+/-0.002	3.395	/			
3.495	+/-0.002	3.495	/			
4.551	+/-0.002	4.551	/		VRN	
4.595	+/-0.002	4.595	/			
4.687	+/-0.002	4.686	/			
4.734	+/-0.002	4.734	/			
6.651	+/-0.002	6.651	/			

DART AEROSPACE LTD		Work Order:	130857
Description: Body		Part Number:	646.9710
Inspection Dwg: 646.9700 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	.202	/		VERW	
Ø0.177	+0.005/-0.001	.178	/		~	
7.026	+/-0.005	7.027	/		HG	
4.245	+/-0.005	4.245	/		VERW	

Measured by: SL	Audited by: B.A.	DAS	Preliminary Approval:
Date: 15-3-28	Date: 15/03/31	08 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	13.06.03	New Issue	KJ	
B	13.07.18	Dwg Rev updated	KJ	
C	14.01.21	Dwg Rev updated	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27987**

Purchase Order Date 4/1/2015

PO Print Date 4/16/2015

Page Number 4 of 8

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

9	130854	646.9710 BODY REV. C	4/24/2015	3.00	\$14.50	\$43.50
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$43.50

10	130445	647.1712 GUSSET REV. C	4/24/2015	7.00	\$12.65	\$88.55
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$88.55

12	131001	646.3810 BRACKET REV. N/C	4/24/2015	6.00	\$6.55	\$39.30
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$39.30

Note:

4/16/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150296 PO: PO27987 Line:		
10 ea	Part: 647.1511 LOWER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150297 PO: PO27987 Line:	Rev:	
13 ea	Part: 647.9710 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150298 PO: PO27987 Line:	Rev:	
5 ea	Part: 649.8310 CUTTER BODY HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150299 PO: PO27987 Line:	Rev: N/C	
3 ea	Part: 646.9710 BODY HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150300 PO: PO27987 Line:	Rev: C	SP15-04-24.
7 ea	Part: 647.1712	Rev:	



A.T.G. Industries Inc.
 731, rue Industrielle Rd.
 PLATING DEPARTMENT
 Rockland, On K4K 1T2
 Canada
 Ph: (613) 446-4544
 Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ship To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150309 PO: PO27987 Line:		
2 ea	Part: D4703-043 Rev: A LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150310 PO: PO27987 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/4/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			